

Date: Wednesday, 11/22/2006 1:40:04 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER		
Job Number	: 29652					
Estimate Number	: 11167					
P.O. Number	: N/A		Part Number	: D32783		
This Issue	: 11/22/2006 S.O. No. : N/A		Drawing Number	: D3278 REV B		
Prsh Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: B		
Previous Run	: 29238		Material	: N/A		
Written By			Due Date	: 11/29/2006 Qty: 50 Um: Each		
Checked & Approved By						
Comment	: Est. A04.04.19 New issue KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MDELRINS0125X300	Black Delrin Comment: Qty.: 0.0361 sf(s)/Unit Total : 1.8060 sf(s) Black Delrin Use DT8685 Router Table. Material: Black Delrin/UHMW 0.125" thick (M-DELRIN-S0.125x30.0) Identify for D3278-3 Batch: M101657
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3278 Dwg Rev: B Prog Rev: B
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACER

Job Number: 29652

Part Number: D32783

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



x49

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'sink as per dwg D3278

ml 06/11/27

2-Deburr

6.0 QC5

INSPECT WORK TO CURRENT STEP



46

Comment: INSPECT WORK TO CURRENT STEP

06/11/27

7.0 PACKAGING 1

PACKAGING RESOURCE #1



3X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STY18

Re 06/11/28 (46) COMPUTER

8.0 QC21

FINAL INSPECTION/W/O RELEASE



46

Comment: FINAL INSPECTION/W/O RELEASE

06/11/28

Job Completion



C20611128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/21	6	4 parts SCRAP C sink was to deep	<i>JS</i> <i>Opps</i>	destroy	SAD 06/11/21	<i>MM</i> 06/11/21	<i>B</i> <i>MM</i>	<i>MM</i> 06/11/21

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29652
Description: Spacer	Part Number:	D3278-3
Inspection Dwg: D3278	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article **□** Prototype

Measured by:	SAD	Audited by:	<u>AA</u>	Prototype Approval:	N/A
Date:	06/11/26	Date:	01/11/27	Date:	N/A

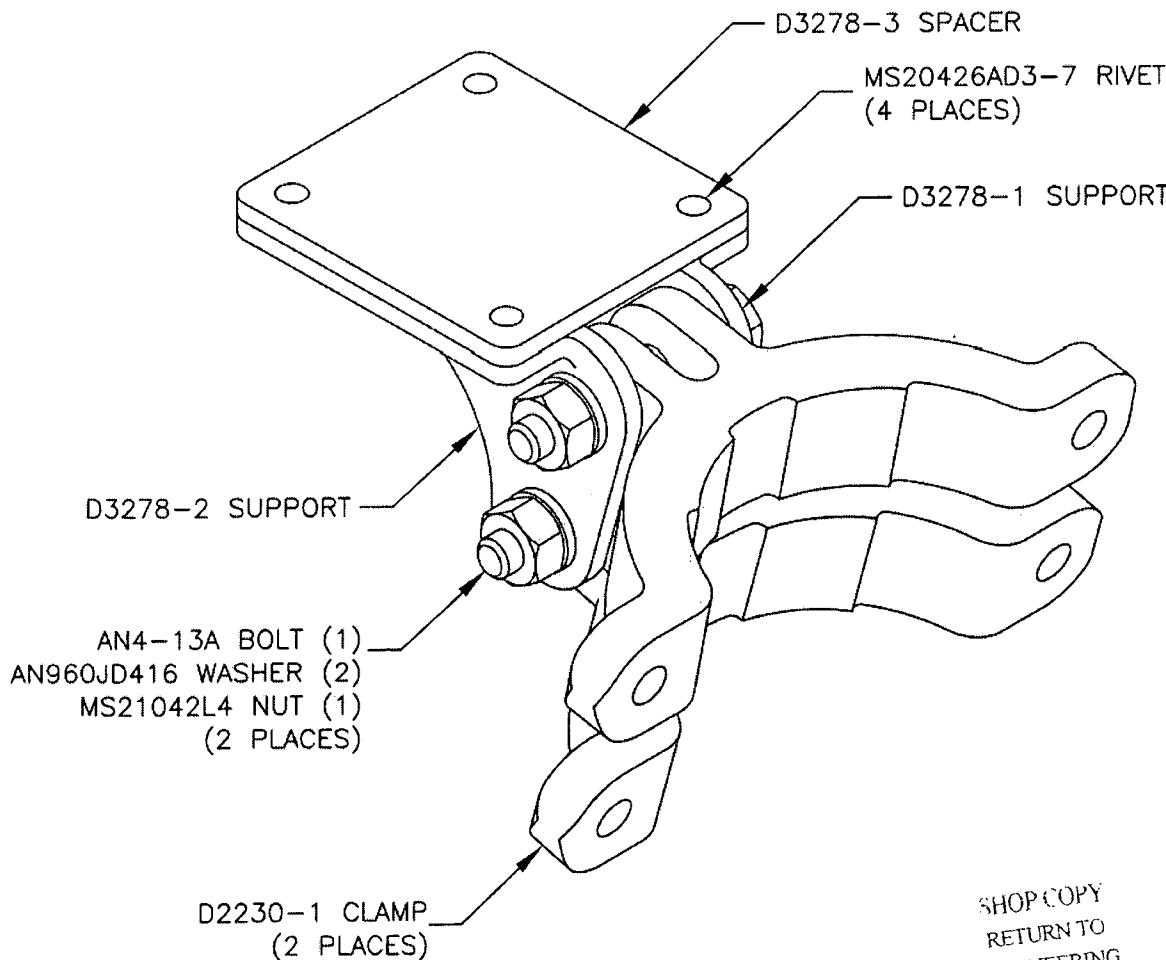
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	



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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

RELEASED
05.04.04

D3278-041 SUPPORT ASSEMBLY



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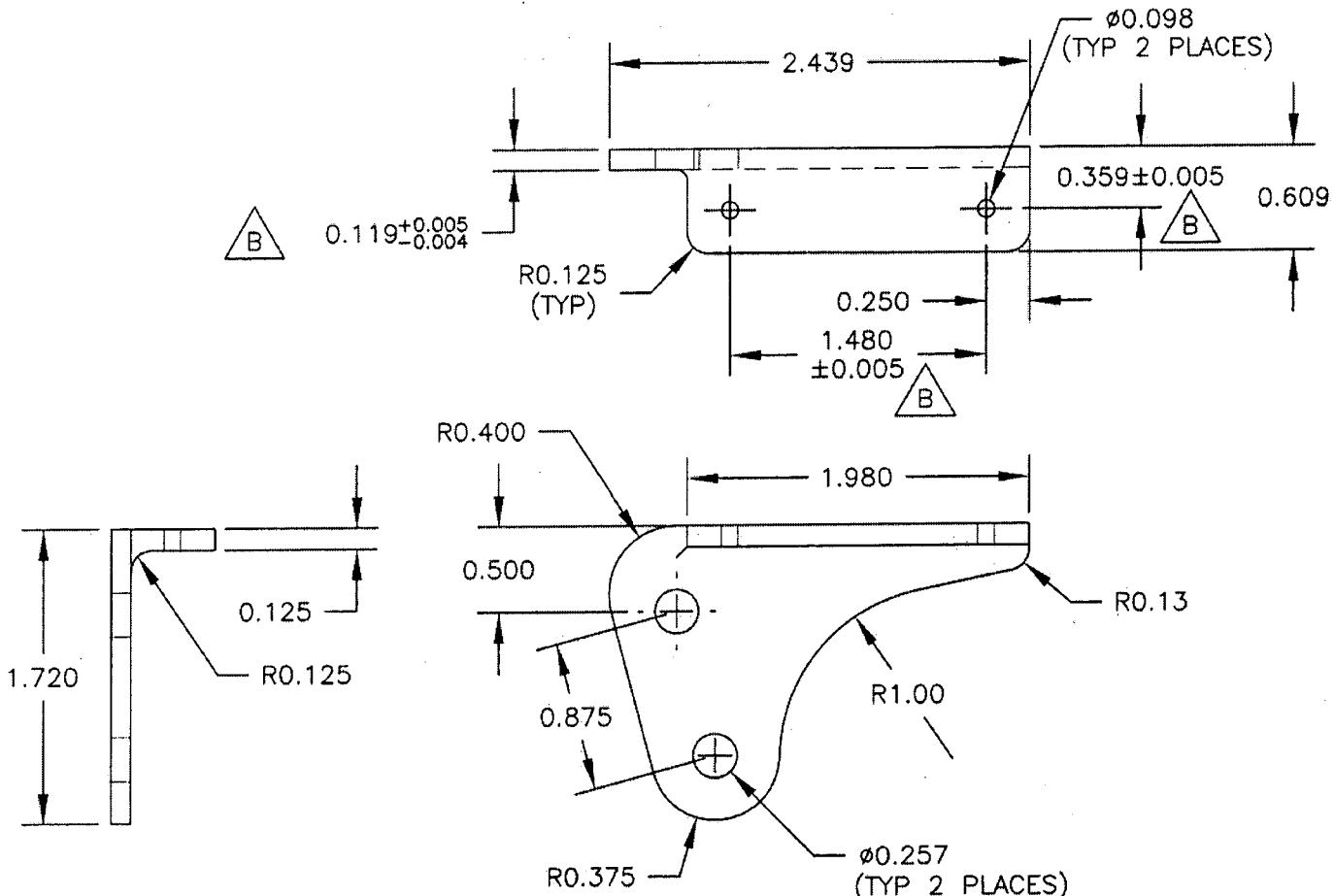
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278	REV. B SHEET 2 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[initials]*D3278-1 SUPPORT (SHOWN)D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250^{7/17})
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

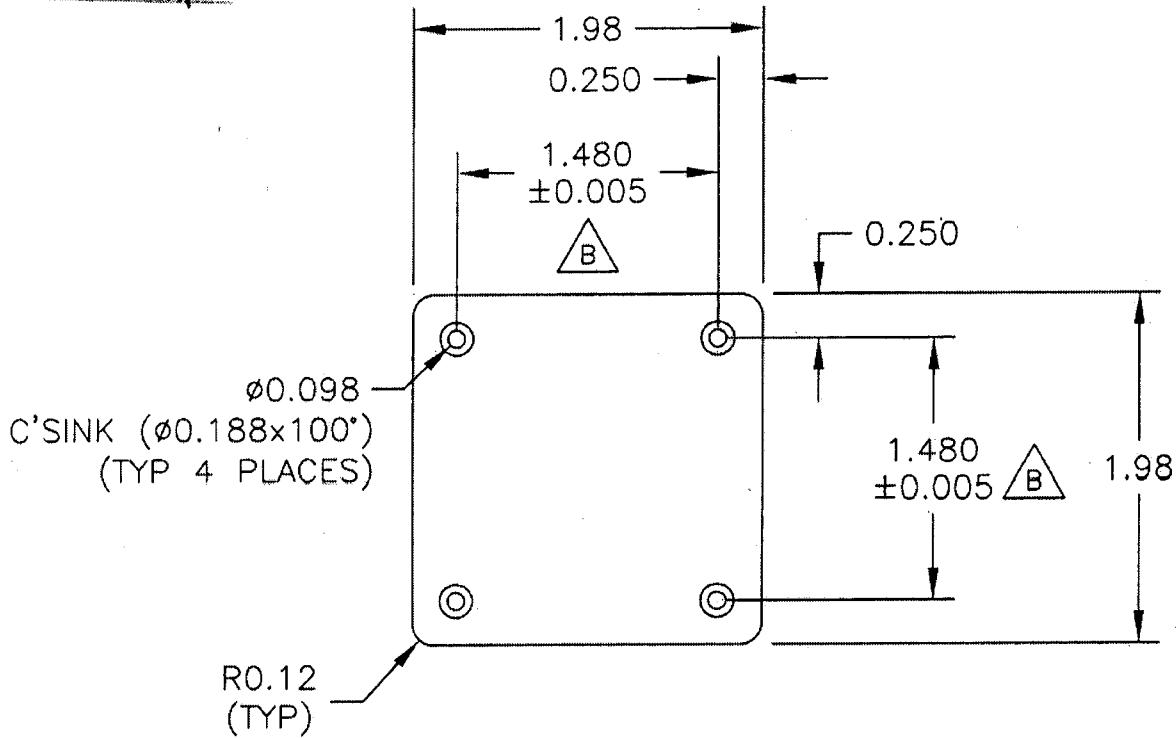
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MC 29652

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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278
DATE 05.03.31	TITLE	REV. B SHEET 3 OF 3 SCALE 1:1 SUPPORT ASSEMBLY

RELEASED

05.04.04 *[initials]*D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR UNCONTROLLED COPY SUBJECT TO AMENDMENT
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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